

Work Order ID 56894

March 12, 2010 10:48:35 AM



Page 1

Item ID: D3121-141

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 19/03/2010 Start Qty: 9.00



Cust Item ID:

Required Date: 31/03/2010 Req'd Qty: 9.00



Customer:

Reference:

Ind 10.03.12

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3121

Rev E

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Ind 10/03/24

9

0

Jeaspa Bandsaw

Cut blanks: (1.250" x 2.000") 6.600" long

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

H.A 10/03/28

HAAS CNC vertical machine #1

1-Machine D3121-111 as per Folio FA361 and Dwg D3121 Identify as D3121-111; 2-Deburr; 3-Scribe batch number

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

H.A 10/03/29

Ind 10.3.3

9

Quality Control

Work Order ID 56894

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Page 2

Item ID: D3121-141

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Cust Item ID:

Required Date: 31/03/2010 Req'd Qty: 9.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

SP 10/03/30

9

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble D3121-141 as per Dwg D3121.

SP 10/03/31 9

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SP 10/03/31

9

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Item Name: Bracket Assembly

Start Date: 19/03/2010 Start Qty: 9.00



Cust Item ID:

Required Date: 31/03/2010 Req'd Qty: 9.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: **ST235A** 0.00



Packaging

Memo

0.00

Packaging

CX 10/3/31 7

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/06 **HJ**

BS 10-4-5
(9)

Picklist Print

March 12, 2010 10:48:35 AM

Page 1

Work Order ID: 56894

Parent Item: D3121-141

Parent Item Name: Bracket Assembly

Comments: IPP Rev:Pick:A 04.02.18: New issue: KJ/DS
IPP Rev:B ECN 1060 07-11-12 DD verified by: EC
IPP Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC

Start Date: 19/03/2010


Required Date: 31/03/2010

Start Qty: 9.00

Required Qty: 9.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3121-21		Manufactured	No			140	Each	26.0000	9.0000			
												
Bolt												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST235	26	
46032	5	
50096	10	
54769	2	
54797	9	

D3121-241	Manufactured	No			100	Each	63.0000	9.0000			
											
Bearing Assembly											

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST235B	63	
54770	1	
55005	13	
56419	49	

Handwritten signature
9/5/10/03/31

Handwritten signature
9/5/10/03/31

Handwritten signature
2/7

Picklist Print

March 12, 2010 10:48:35 AM

Page 2

Work Order ID: 56894

Parent Item: D3121-141

Parent Item Name: Bracket Assembly

Comments: IPP Rev:Pick:A 04.02.18! New issue: KJ/DSI!
 IPP Rev:B ECN 1060 07-11-12 DD verified by: EC
 IPP Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC

Start Date: 19/03/2010

Required Date: 31/03/2010

Start Qty: 9.00

Required Qty: 9.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
M174B1.250X02.000		Purchased	No			140	f	29.0089	5.2105			



17-4 SS Bar 1.250 x 2.00

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

29.00894736

109851

0.73894736

113437

2.67

→ 113568

25.6

5.2105 *ml* 10/03/24

March 12, 2010 10:48:35 AM

Shop Packet Print

Page 2

DART AEROSPACE LTD		Work Order: 56894
Description: Bracket		Part Number: D3121-111
Inspection Dwg: D3121 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

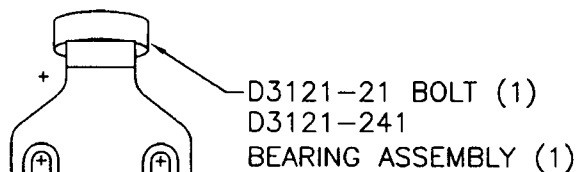
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	Ø0.3935	✓			
0.75	+/-0.030	0.750	✓			
0.375	+/-0.010	0.375	✓			
2.14	+/-0.030	2.137	✓			
1.96	+/-0.030	1.960	✓			
0.280	+/-0.010	0.280	✓			
3.330	+/-0.010	3.330	✓			
3.630	+/-0.010	3.630	✓			
R0.25	+/-0.030	R0.250	✓			
R0.375	+/-0.010	R0.375	✓			
Ø0.201	+0.005/-0.001	Ø0.200	✓			
0.100	+/-0.010	0.103	✓			
4.580	+/-0.010	4.580	✓			
6.18	+/-0.030	6.190	✓			
5.89	+/-0.030	5.890	✓			
0.080	+/-0.010	0.080	✓			
0.300	+/-0.010	0.300	✓			
30°	+/-0.1°	30°	✓			
R0.25	+/-0.030	R0.250	✓			
0.130	+/-0.010	0.131	✓			
0.664	+/-0.010	0.664	✓			
0.381	+/-0.010	0.382	✓			
0.201	+/-0.010	0.201	✓			
0.400	+/-0.010	0.397	✓			
0.580	+/-0.010	0.581	✓			
100°	+/-0.1°	100°	✓			
0.032	+0.000/-0.010	0.030	✓			

Measured by: H.A	Audited by: SP	Prototype Approval: N/A
Date: 10/03/29	Date: 10/03/30	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue P/O D3121-141	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	
D	08.01.16	Dimensions updated per Dwg Rev. E	KJ/EC/DD	
E	08.05.28	Tolerance revised for Ø0.201 dimension	KJ/DD	

DART

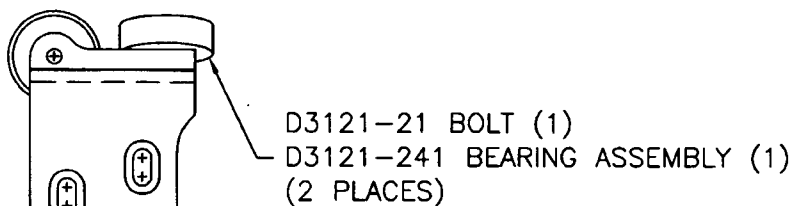
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 2 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3121-111 BRACKET

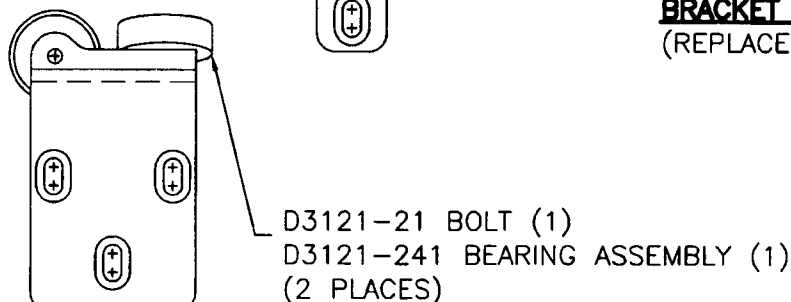
D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)

RELEASED
07.11.07



D3121-113/-114 BRACKET

D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-03/-04)



D3121-115/-116
BRACKET

D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-05/-06)

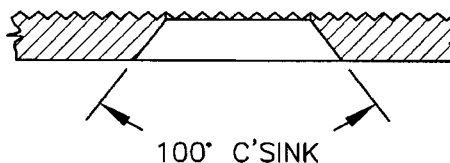
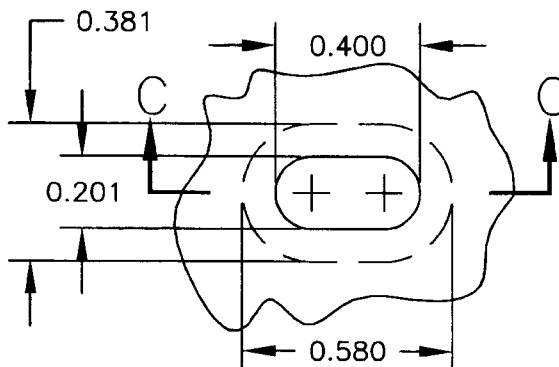
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DART

DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 3 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

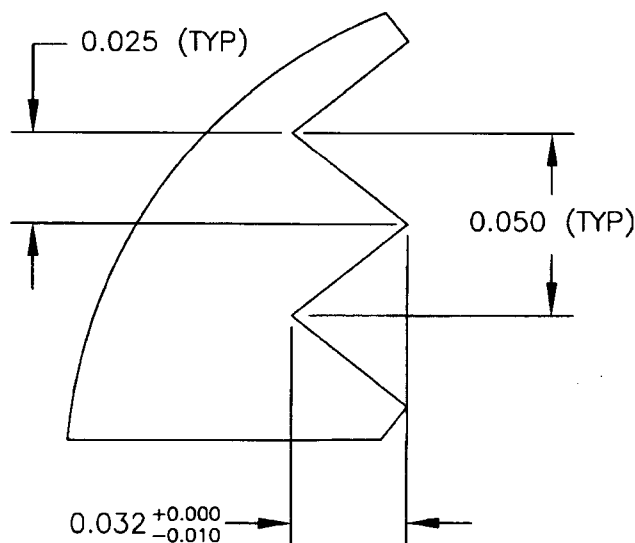
**DETAIL A:
SLOT DETAIL**
SCALE 2:1
VIEW ROTATED



**SECTION
C-C**

RELEASED
07.11.07

**DETAIL B:
RIDGE DETAIL**
PARTIAL SECTION
SCALE 1:20

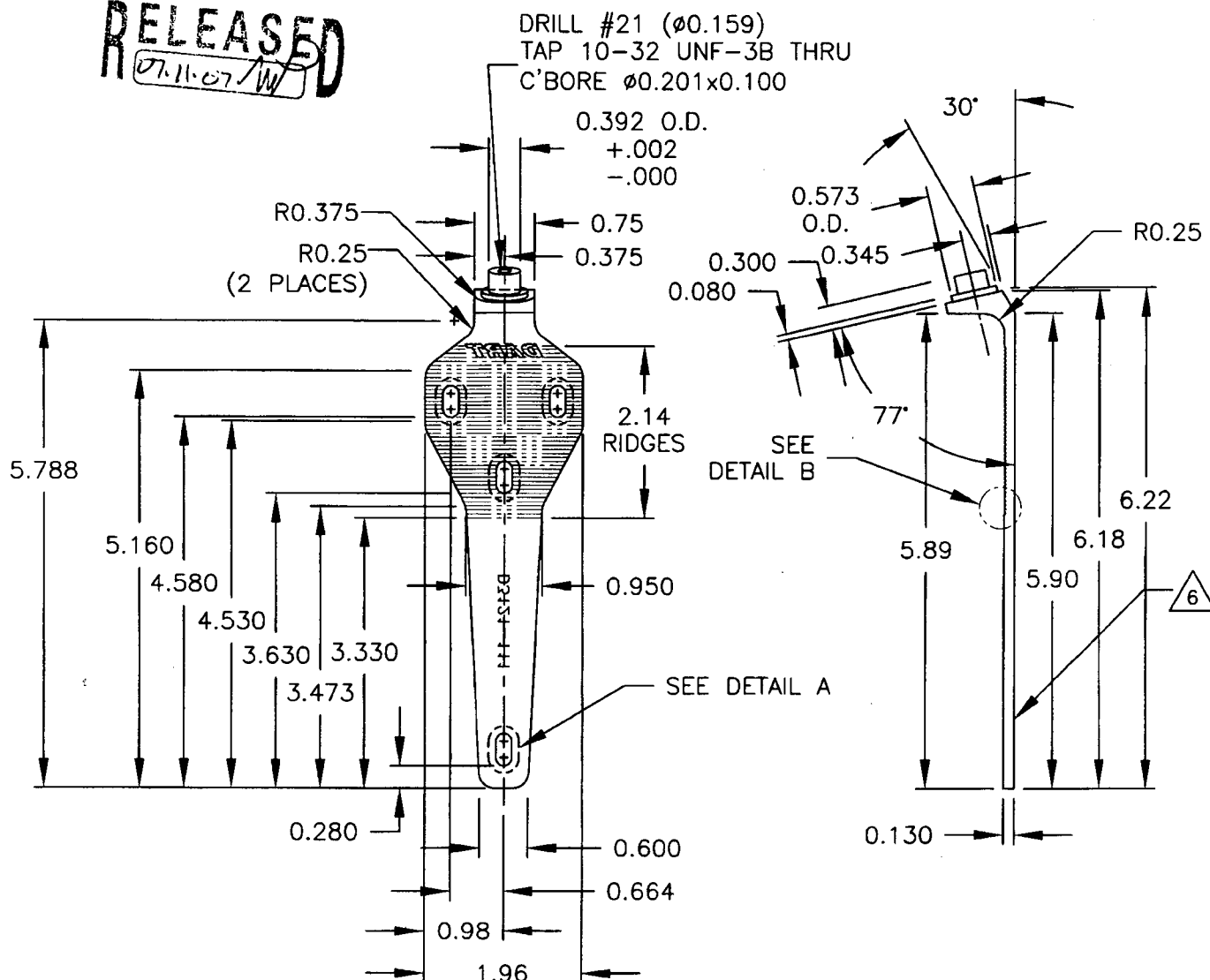


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DART

DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 7 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07/W**D3121-111 BRACKET**

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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